

Ship March 11<sup>th</sup> @ 10:00 Ret today

Work Order ID 113857

\*113857\*

Page 1

March-04-14 10:56:32 AM

Item ID: D4445-1 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Cable Guard  
Start Date: 2/24/14 Start Qty: 6.00 \*6\* Cust Item ID:  
Required Date: 2/24/14 Req'd Qty: 6.00 \*6\* Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4445	A

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4445

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

A cut at 78.00" Long

110

0.00

\*110\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

6 0 Im 14-03-4

6 0 Im 14-03-4



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\*113857\*

Page 2

Item ID: D4445-1

Accept

\*N19000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Cable Guard

Start Date: 2/24/14 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB072 & dwg D4445, FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Deburr as required								
130		0.00							
<b>*130*</b>	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									
140		0.00							
<b>*140*</b>	QC8- Inspect parts - second check	0.00							
QC	<b>Memo</b>	0.00							
Quality Control	ENSURE D4445-1 IS MACHINE TO LENGTH AS PER DWG.								



# Work Order ID 113857

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**\*113857\***

Page 3

Item ID: D4445-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cable Guard  
 Start Date: 2/24/14 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 2/24/14 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST2014</u> (4X)								
<b>*150*</b>									
Packaging	Memo 2x ship	0.00				6X	DAS 28 9-88	14-03-6	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00						14-03-6	
Quality Control									

me  
14-3-6



# Picklist Print

Page 1

March-04-14 10:56:32 AM

Work Order ID: 113857

**\*113857\***

Parent Item: D4445-1

**\*D4445-1\***

Parent Item Name: Cable Guard

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11/10/05 NEW ISSUE JFS VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

425.7082

6

**\*MUHMWB10\***

**\*\***

*Ac 03-04-14*

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

425.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

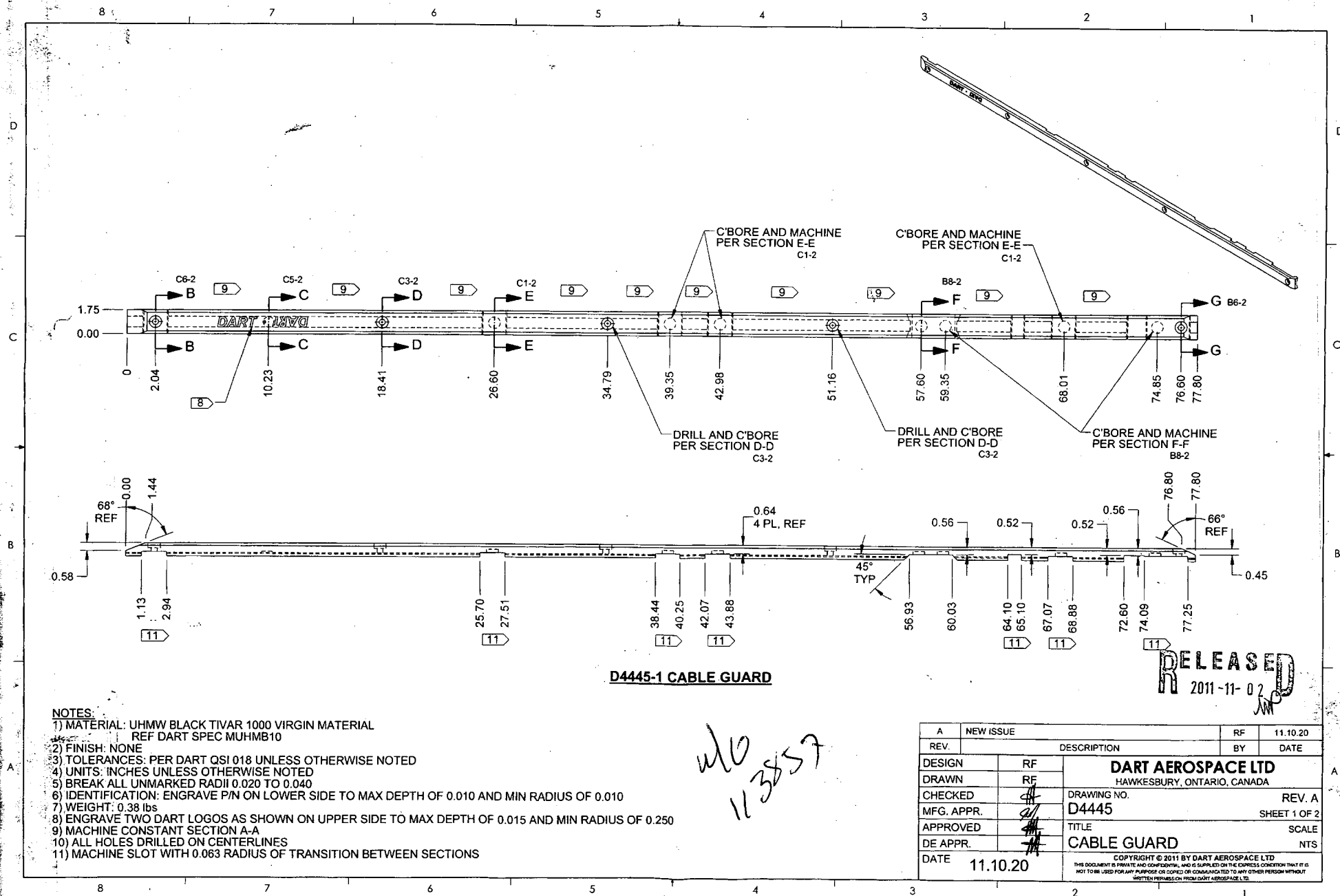
m128011

57

m128267

234

*6*



RELEASED  
2011-11-02

A NEW ISSUE		RF	11.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.10.20		

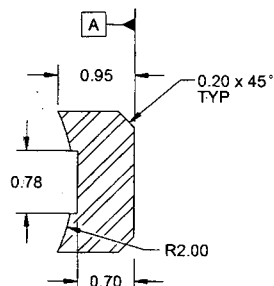
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. A
D4445	SHEET 1 OF 2
TITLE	SCALE
CABLE GUARD	NTS

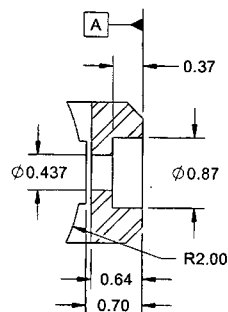
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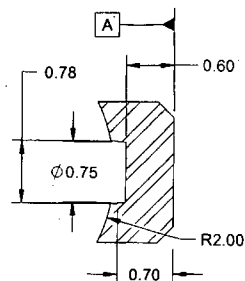
8 7 6 5 4 3 2 1



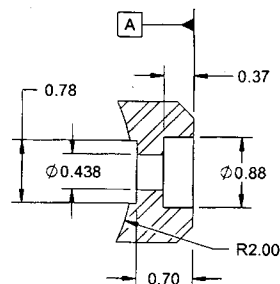
**SECTION A-A** C1-1  
SCALE 3.5X TO C8-1



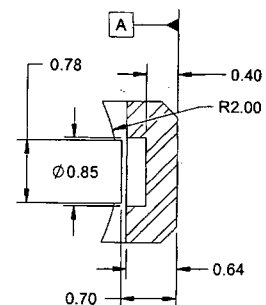
**SECTION B-B** C8-1  
SCALE 3.5X



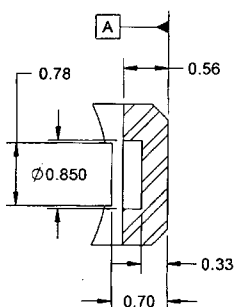
**SECTION C-C** C7-1  
SCALE 3.5X



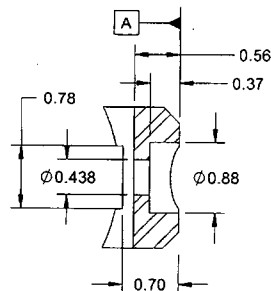
**SECTION D-D** C3-1  
SCALE 3.5X C4-1  
3 PL C6-1



**SECTION E-E** C2-1  
SCALE 3.5X C4-1  
4 PL C5-1  
C6-1



**SECTION F-F** C1-1  
SCALE 3.5X C3-1  
3 PL



**SECTION G-G** C1-1  
SCALE 3.5X

RELEASED  
2011-11-02

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4445	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CABLE GUARD	NTS
DATE	11.10.20	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	113857
<b>Description:</b> CABLE GUARD		<b>Part Number:</b>	D4445-1
<b>Inspection Dwg:</b> D4445 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
68.88	+/- .030	68.875	✓		Tape	GA-12
0.52	+/- .030	0.516	✓		Vern	GA-01
77.25	+/- .030	77.235	✓		Tape	GA-12
77.80	+/- .030	77.80	✓		"	"
0.45	+/- .030	0.450	✓		Vern	GA-01
0.95	+/- .030	0.938	✓		"	"
0.78	+/- .030	0.782	✓		"	"
0.70	+/- .030	0.690	✓		"	"
R2.00	+/- .030	R2.00	✓		R-6	ref.
0.20 x 45°	<del>+/- .030</del> +/- .125	0.190 x 45°	✓		Vern	GA-01
φ0.437	<del>- .001</del> + .006	φ0.436	✓		"	"
φ0.87	+/- .030	φ0.877	✓		"	"
φ0.75	+/- .030	φ0.753	✓		"	"
0.60	+/- .030	0.617			Mic	GA-03
φ0.88	+/- .030	φ0.877	✓		Vern	GA-01
0.37	+/- .030	0.373	✓		"	"
0.64	+/- .030	0.630	✓		"	"
φ0.850	+/- .010	φ0.853	✓		"	"

<b>Measured by:</b>	Y. A. 08
<b>Date:</b>	14/03/05

<b>Audited by:</b>	<i>Amf</i>
<b>Date:</b>	14/03/06

<b>Preliminary Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 113857
<b>Description:</b> CABLE GUARD	<b>Part Number:</b> D4445-1
<b>Inspection Dwg:</b> D4445 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.04	+/- .030	2.035	✓		Vern	CNC-02
10.23	+/- .030	10.217	✓		"	"
18.41	+/- .030	18.407	✓		Tape	GA-12
26.60	+/- .030	26.610	✓		"	"
34.79	+/- .030	34.782	✓		"	"
39.35	+/- .030	39.343	✓		"	"
42.98	+/- .030	42.968	✓		"	"
51.16	+/- .030	51.155	✓		"	"
57.60	+/- .030	57.590	✓		"	"
59.35	+/- .030	59.340	✓		"	"
68.01	+/- .030	68.000	✓		"	"
74.85	+/- .030	74.840	✓		"	"
76.60	+/- .030	76.590	✓		"	"
77.80	+/- .030	77.800	✓		"	"
0.58	+/- .030	0.580	✓		Vern	GA-01
1.44	+/- .030	1.460	✓		"	"
2.94	+/- .030	2.937	✓		"	"
27.51	+/- .030	27.50	✓		Tape	GA-12
40.25	+/- .030	40.25	✓		"	"
43.88	+/- .030	43.85	✓		"	"
60.03	+/- .030	60.015	✓		"	"
0.56	+/- .030	0.560	✓		Vern	GA-01
65.10	+/- .030	65.090	✓		Tape	GA-12

<b>Measured by:</b> J. A. 08
<b>Date:</b> 14/03/05

<b>Audited by:</b>
<b>Date:</b>

<b>Preliminary Approval:</b>
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

